

Date: Friday, 16/05/2008 10:12:55 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	350 SKIDTUBE ASSEMBLY RH
<b>Job Number</b> :	39231		
<b>Estimate Number</b> :	10265		
<b>P.O. Number</b> :		<b>Part Number</b> :	D350636012
<b>This Issue</b> :	16/05/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2750 UNDER REVIEW
<b>First Issue</b> :	13/05/2008	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	38547	<b>Drawing Revision</b> :	E
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :		<b>Due Date</b> :	05/06/2008
<b>Comment</b> :	Est Rev:I 02-09-25 Rearranged procedure steps KJ Est Rev:J 06-03-29 As per Rev D EC Est Rev:K 06-07-13 As per dsi9343 EC Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC Est Rev:M 08-04-22 update steps 4,13 DD verified by:EC		
<b>Qty:</b>	1	<b>Um:</b>	Each

**Additional Product**

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL  
Photocopy blue file and type labels per PPP D350-636-012 CHG 004  
PER DSI9413 REV.A

*508066105*

2.0	D26003BENT	Extrusion Bent
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Pick:  
Qty Part Number Description Batch  
1 D2600-3-Bent Extrusion (Bent) *30463*  
*30462 SL 8-5-21*

3.0	D2744	Cap
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Cap  
Batch: *37768* *BE 08/05/23*

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------

**Comment:** LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

*5085-22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 16/05/2008 10:12:56 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 39231

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D34901

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: R33824

BF 08/05/28

11.0

D34903

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: R33825

BF 08/05/28

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch: R337767

BF 08/05/28

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail B, E, ground handling and float holes per dwg D2750 (welding instructions on  
sheet 4)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 107804

exp. date: 8-2-31

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 4)

5285-27

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 39231

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Aluminum Rod batch: M107877 BF 08/05/28

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750

11-Deburr holes

28-528

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/05/28 (P)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/28 (P)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

08/06/03 (P)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

3:35

OVEN TEMPERATURE:

320°

FINISH TIME:

4:05

08-06-03 (P)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

08/06/04 (P)

19.0

ALS41032225

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

Insert

Batch: M100489

08/06/04 (P)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 39231

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

AND DSI9413 REV.A

FL 08/06/04

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B36230

FL

22.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B38867

FL

23.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B38565

FL

24.0

D35371

Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch: B36426

FL

25.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: B39279

FL

26.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: B39277

FL 08/06/04 ①

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 39231

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Wearplate *B39276*

*FL*

28.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Gasket *B39361*

*FL*

29.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Wearshoe *B39479*

*FL*

30.0

D36721

Phenolic Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)  
Phenolic Washer *B39275*

*FL*

31.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Screw *m108062*

*FL*

32.0

AN526C1032R18

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Screw *m10807A*

*FL*

33.0

D36311

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)  
WASHER  
Batch: *B38139*

*FL*

34.0

D3488042

Blade Fitting Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Blade Fitting, RH  
Batch: *B38466*

*FL 08/06/04 (1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 39231

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D3492041

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY

\*Batch: 038182 (x1) 038756 (x7)

FL

36.0

D3492043

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 038 563

FL

37.0

AN3C5A

Bolt



Comment: Qty.: 34 8.0000 Each(s)/Unit Total: 34 8.0000 Each(s)

Bolt

Batch: m107737 (x16) m107862 (x18)

FL

38.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: m105300

FL

39.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: \_\_\_\_\_

u17 080605

40.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: m107685

FL

41.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BOLT

Batch: m106896

FL 08/06/04 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 39231

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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42.0	AN960C10L	washer
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Comment: Qty.: <sup>38</sup>46.0000 Each(s)/Unit Total: <sup>38</sup>46.0000 Each(s)

washer

Batch: m108077

FL

43.0	AN960C816L	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WASHER

Batch: m107520

FL

44.0	MS210436	NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch: m107736

FL

45.0	MS21083C8	NUT
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: m107939

FL

46.0	NAS1515H3L	WASHER
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

Batch: m107394

FL

47.0	NAS1515H8L	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: \_\_\_\_\_

u / 4 5006/05

48.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"

batch: m106096

FL 08/06/04 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 39231

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: m107804

EXP DATE: 08/10

4-Coat all exposed fasteners with "LPS Procyon"

batch: m108251

*FL 08/06/04*

49.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*m1 08 06 04 (1)*

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

51.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 30843

*JS 08/06/05 (1)*

52.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M107520

*JS 08/06/05 (2)*

53.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M107939

*JS 08/06/05 (2)*

54.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M107924

*JS 08/06/05 (2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 39231

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

55.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M107581

JS 08/06/05 @

56.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: 38102

JS 08/06/05 @

57.0

D35321

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

spacer

Batch: 38101

JS 08/06/05 @

58.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

JS 08/06/05 @

59.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

G 08/06/05 @

60.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1  
D 08/06/06

Job Completion



W 08/06/06

39231

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV E

REF FAA STC: SR00646SE

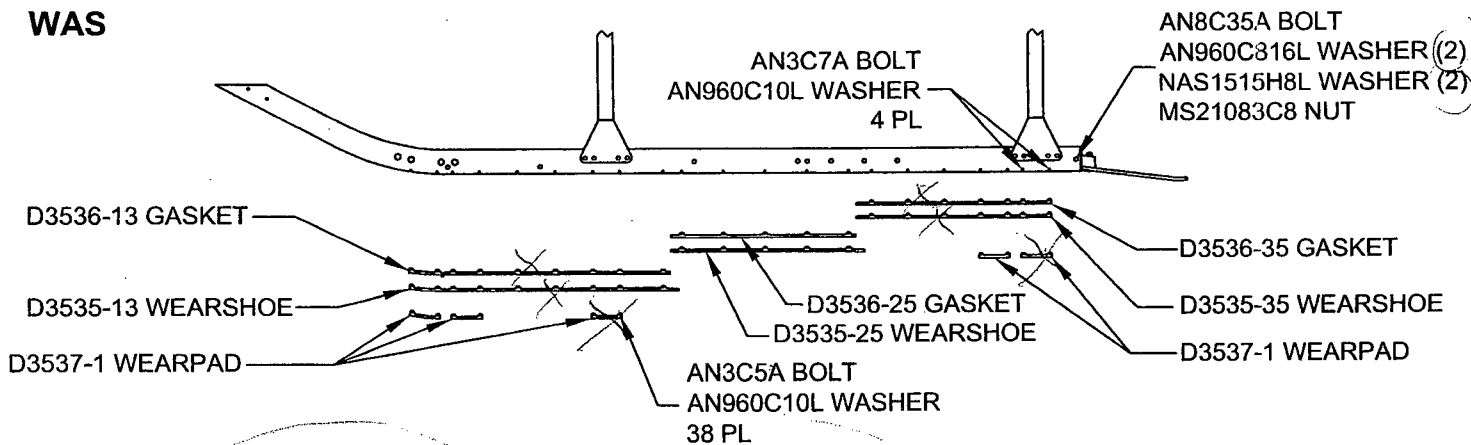
REF CANADIAN STC: SH99-7

FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004:

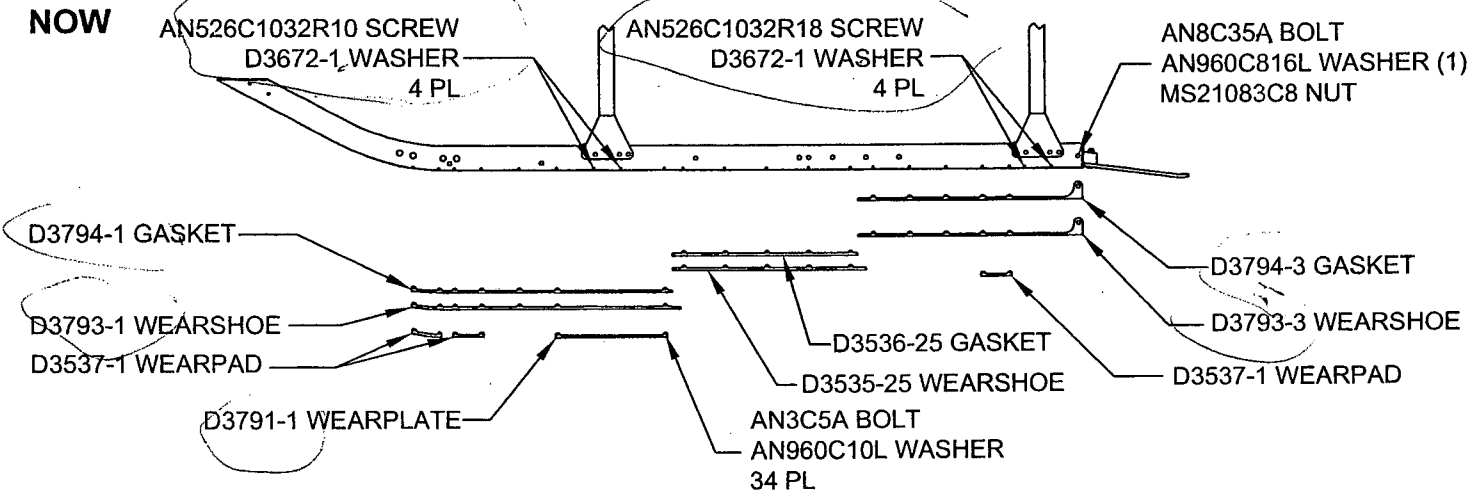
TO IMPROVE THE INSTALLATION OF THE DART D350-636-011/-012/-013/-014 SKIDTUBES ONTO THE CROSSTUBES, THE INSTALLATION AND PART NUMBERS OF THE FWD AND AFT WEARSHOES/GASKETS HAVE BEEN REVISED AS SHOWN IN FIGURE 1 BELOW.

FOR EXISTING CUSTOMERS THAT WOULD LIKE TO IMPROVE THE INSTALLATION OF THE SKIDTUBE TO THE CROSSTUBE, REFER TO PAGE 3 OF THIS DOCUMENT

**WAS**



**NOW**



**FIGURE 1 - D350-636-011/-012/-013/-014 AT CHG 004 AND INSTALLATION OF DSI 9413-011**  
(LOCATION OF AN526C1032RXX SCREWS ARE NOT TO BE USED TO MOUNT WEARSHOES)

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION		BY DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	J	DRAWING NO.	REV. A
MFG. APPR.		DSI 9413	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE INSTALLATION	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

**PRELIMINARY ISSUE**

**DART**

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>HA</i>	DRAWING NO. <b>D2750</b>	REV. E SHEET 1 OF 5
DATE <b>07.05.17</b>		TITLE <b>350 SKIDTUBE ASSEMBLY</b> SCALE NTS	
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3 / D2750-4; INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133 / 9157	
E	07.05.17	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY(38) NAS1515H3L; REMOVE QTY(10) NAS1515H8L; REMOVE D2741, QTY(2) AN960C816; REMOVE QTY(2) MS21083C8	

**RELEASED**  
07-08-02

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-13	WEARSHOE
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3535-35	WEARSHOE
1	1	1	1	D3536-13	GASKET
1	1	1	1	D3536-25	GASKET
1	1	1	1	D3536-35	GASKET
5	5	5	5	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
42	42	42	42	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
2	2	2	2	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER
2	2	2	2	NAS1515H8L	WASHER

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2750</b>	REV. E SHEET 2 OF 5
DATE <b>07.05.17</b>		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS

GENERAL NOTES:

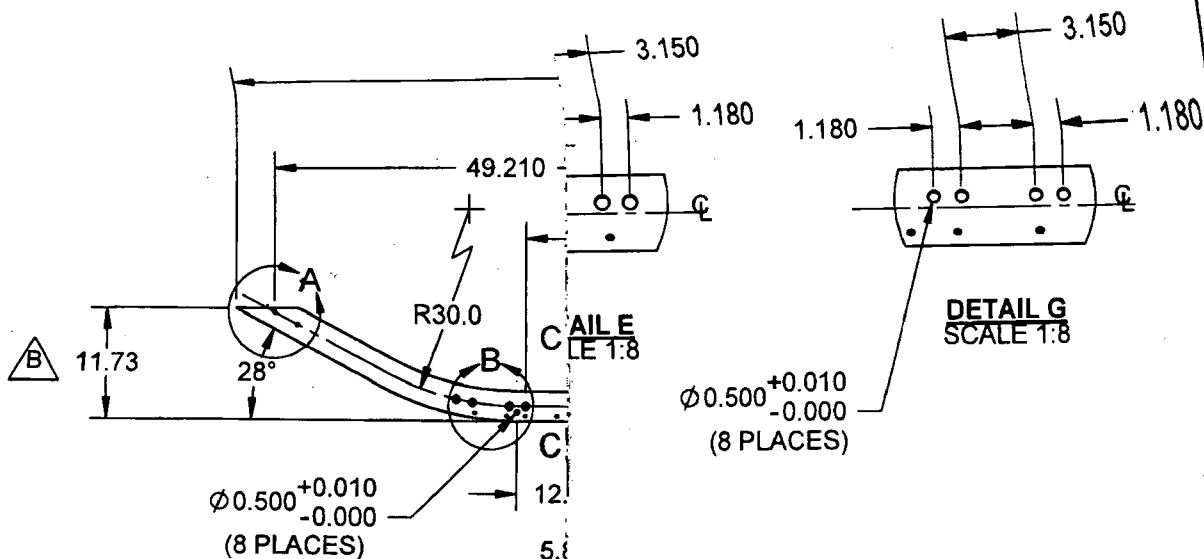
**RELEASED**  
07-08-02 *[Signature]*

1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ( $\emptyset 0.297$ ) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF. POWDER COATING WITH MEK DEGREASER.

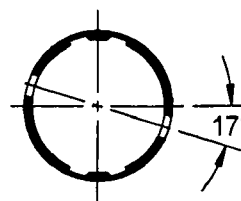
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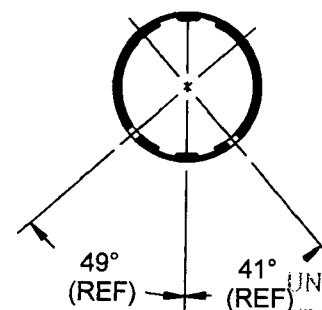
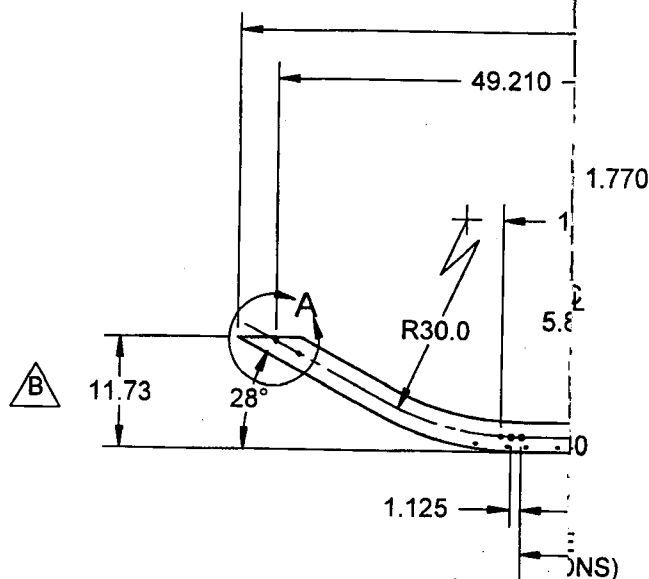


**D2750**  
**D2750-2**



**SECTION D-D**  
**SCALE 1:4**

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67-08-02



**SECTION F-F**  
**SCALE 1:4**

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ED [Signature]	DRAWING NO. <b>D2750</b>	REV. E SHEET 3 OF 5
	TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE 1:20

**D2750**  
**D2750-2**

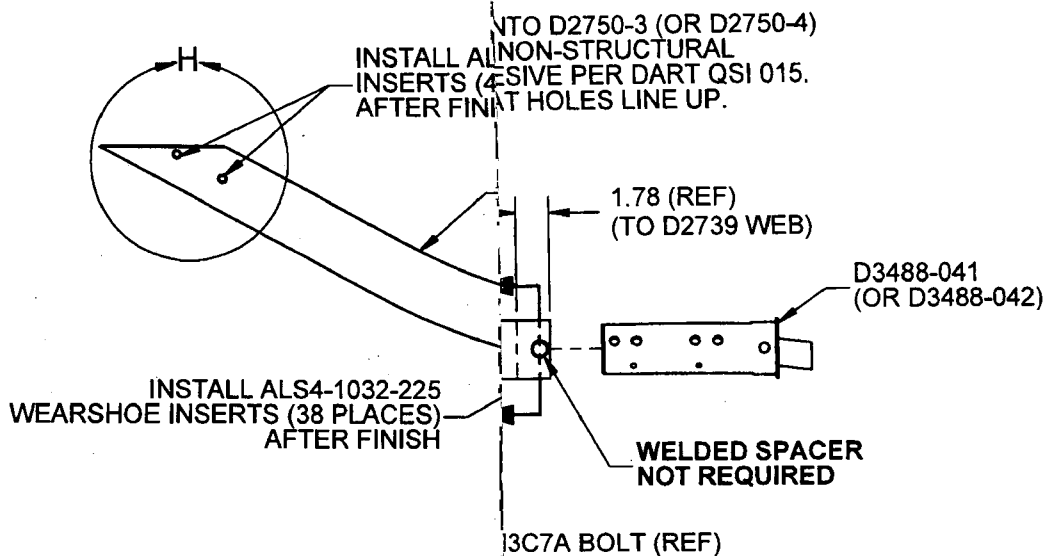
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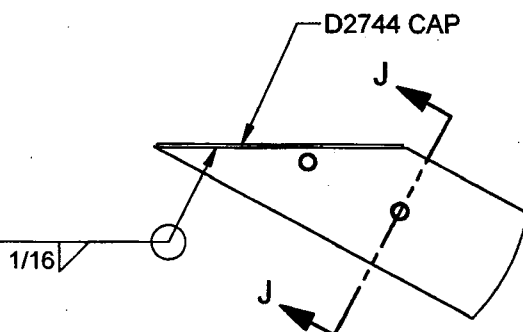
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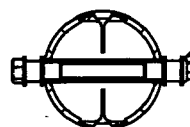
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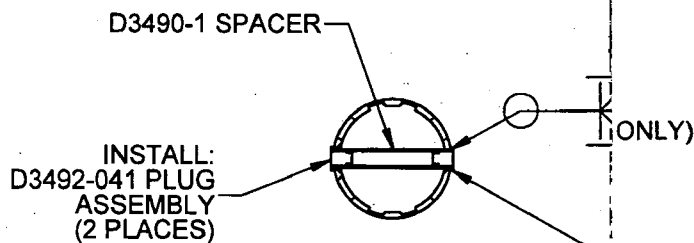
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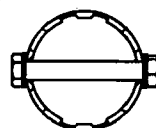
**DETAIL H**  
SCALE 1:5



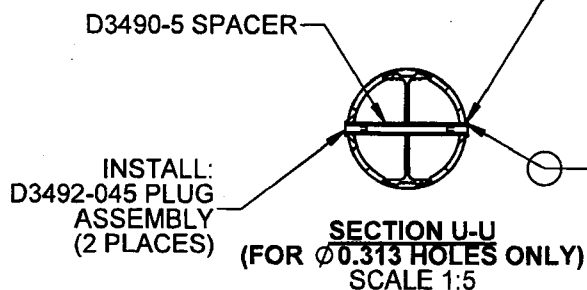
**SECTION Q-Q**  
SCALE 1:5



**SECTION T-T**  
(FOR  $\phi 0.500$  HOLES ONLY)  
SCALE 1:5



**SECTION R-R**  
SCALE 1:5



**SECTION U-U**  
(FOR  $\phi 0.313$  HOLES ONLY)  
SCALE 1:5

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**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

DRAWING NO.  
**D2750**

REV. E

SHEET 5 OF 5

TITLE

**350 SKIDTUBE ASSEMBLY**

SCALE

1:10

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2

1

NO. 157

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 392301  
Part number: D350 636 012  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Duval Date of Test Coupon 08-05-23  
Welder Barclay Elliot Date of Test Coupon 08-05-28

The above named individual is qualified in accordance with AWS D17.1.2001 to weld



Date: Tuesday, 13/05/2008 9:29:29 AM  
User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY RH  
Job Number : 39231  
Estimate Number : 10265  
P.O. Number : Part Number : D350636012  
This Issue : 13/05/2008 S.O. No. : Drawing Number : D2750 UNDER REVIEW  
Prsht Rev. : NC Project Number : N/A  
First Issue : // Type : CROSSTUBES Drawing Revision : E  
Previous Run : 38547 Material :  
Written By : Due Date : 05/06/2008 Qty: 1 Um: Each  
Checked & Approved By : JLD 08.5.13  
Comment : Est Rev:I 02.09.25 Rearranged procedure steps KJ  
Est Rev:J 06-03-29 As per Rev D EC  
Est Rev:K 06-07.13 As per dsi9343 EC  
Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM  
Verified By:EC  
Est Rev:M 08-04-22 update steps 4,13 DD verified by:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD 08.5.14



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG-003

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent)

3.0 D2744 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch: \_\_\_\_\_

